



Work Order ID 74027

Tuesday, September 20, 2011 1:09:11 PM



Page 1

Item ID: D3213-3

Accept



Setup Start



Revision ID:

Item Name: Door Panel

Stop



Start Date: 9/20/2011 **Start Qty:** 10.00



Cust Item ID:

Required Date: 10/3/2011 **Req'd Qty:** 10.00



Customer:

Reference:

Approvals: Process Plan: *P*

Date: *11-09-20* Tooling: _____ Date: _____

Run Start



QC: _____

Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3213	B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

11-10-26

FLOW CNC Waterjet

2024.063

(10)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



Memo

0.00

11-10-26

Quality Control

Pto →

120

QC8- Inspect parts - second check

0.00



Memo

0.00

S u10128

Quality Control

(X5) (T4)

Dart Aerospace Ltd

W/O: 74027

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: 23213-3 PAR #: N/A Fault Category: Small Fab water jet NCR: Yes No DQA: Date: 11/11/03
 Resolution: Scraps Disposition: Scraps QA: N/C Closed: Date: 11/11/04

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/10/03	#100	Found QH +1 with cut out in bottom of part. P.C. too close to edge of sheet. LOA.	S 11/10/03 05/10/03	scrapt Desig no Rehe QH +1	PK 11/10/03	S 11/10/03	S 05/10/03 11/10/03	S 11/10/03

NOTE: Date & initial all entries

Work Order ID 74027

Tuesday, September 20, 2011 1:09:11 PM

Page 2

Item ID: D3213-3

Accept



Setup Start



Revision ID:

Item Name: Door Panel

Stop



Start Date: 9/20/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 10/3/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130

Operation
Description

Small Fab

Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

0.00

B11-10-28

Small Fab

Small Fab

Memo
Deburr

140



Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Hand Finishing

Memo

0.00

150



QC3- Inspect Part Finish

0.00

QC

Quality Control

Memo

0.00

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 74027

Tuesday, September 20, 2011 1:09:11 PM



Page 3

Item ID: D3213-3

Accept



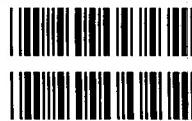
Setup Start



Revision ID:

Item Name: Door Panel

Stop



Start Date: 9/20/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 10/3/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
Description

160



Packaging

Packaging

232

Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

11/10/11

PQ

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

W11/01/11

MF
11-10-31

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NOTE: Date & initial all entries

Picklist Print

Tuesday, September 20, 2011 1:09:15 PM

Page 1

Work Order ID: 74027



Parent Item: D3213-3



Parent Item Name: Door Panel

Start Date: 9/20/2011

Required Date: 10/3/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 05-11-17 JLM
IPP Rev:B Now on Waterjet 07-02-13 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased		No		100	sf	116.5000	0.4714	4.962105			

2024-T3 .063 sheet

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	MAT022	116.5	
	117392	116.5	117392

(10)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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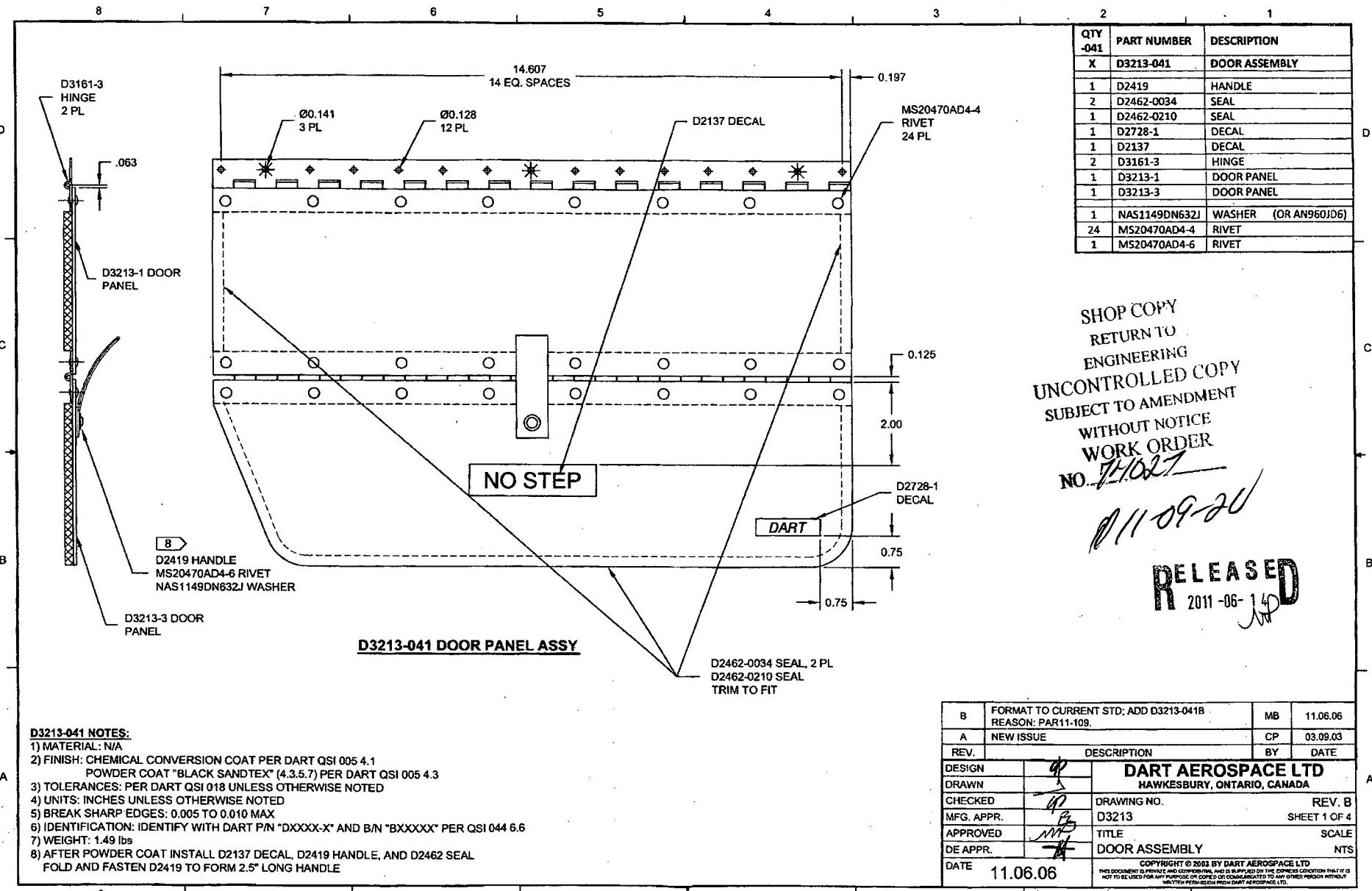
DART AEROSPACE LTD	Work Order:	74027
Description: Door Panel	Part Number:	D3213-3
Inspection Dwg: D3213 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	Audited by:	Prototype Approval:
Date: 11-10-20	Date: 11-10-28	Date: N/A

Rev	Date	Change	Revised by	Approved
A	03.12.15	New Issue P/O D350-567-015/-025/-031	KJ/RF	
B	04.06.15	Tolerance changed for 14.400 dimension	KJ/JLM	
C	08.11.27	Diameter symbol added to dimension 0.128	KJ/EC	



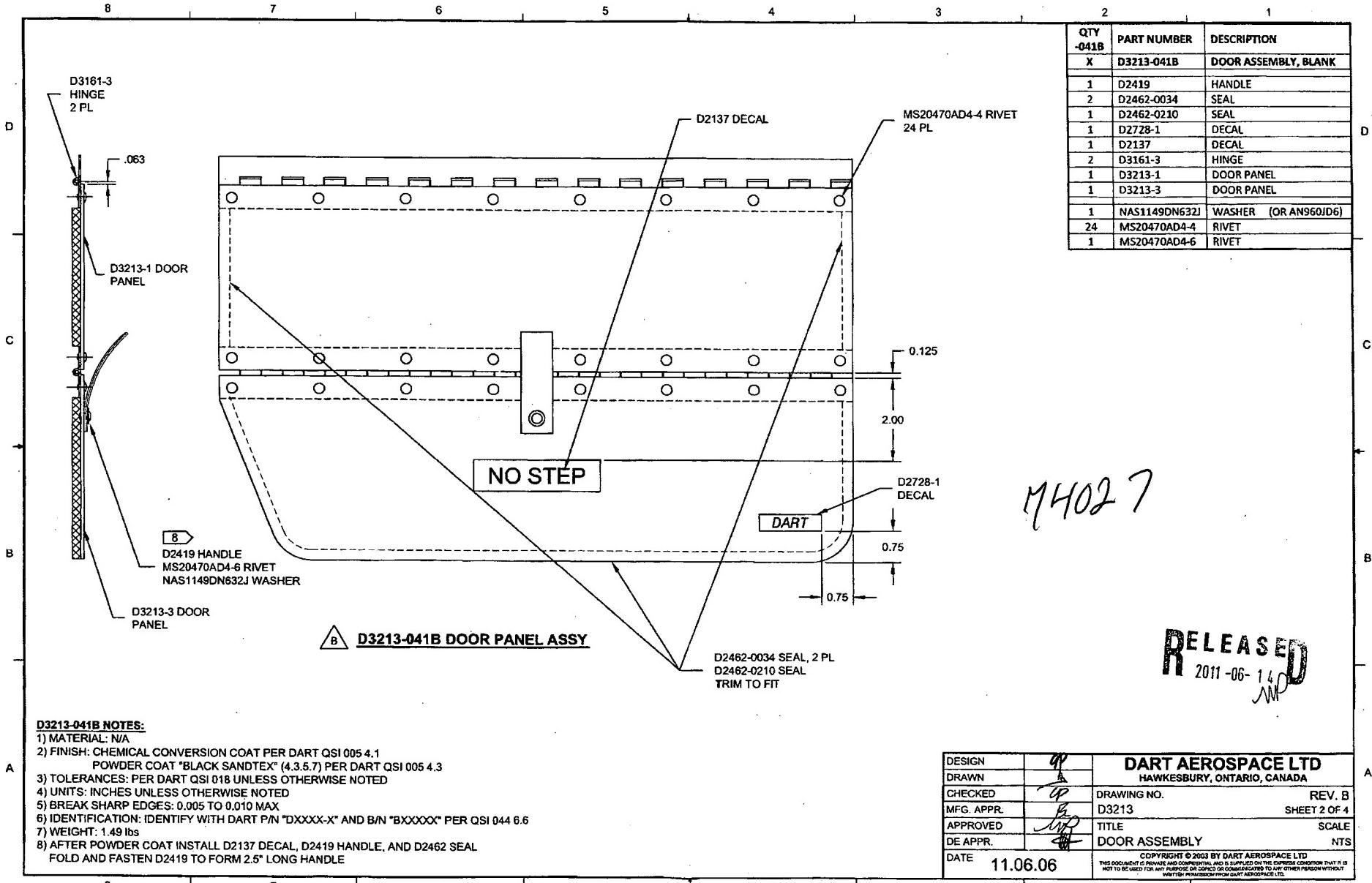
Dart Aerospace Ltd

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DESIGN	PP	DART AEROSPACE LTD	
DRAWN	A	HAWKESBURY, ONTARIO, CANADA	
CHECKED	TP	REV. B	
MFG. APPR.	B	DRAWING NO.	D3213
APPROVED	JMP	SHEET 2 OF 4	
DE APPR.	SAC	TITLE	DOOR ASSEMBLY
DATE	11.06.06	SCALE	NTS

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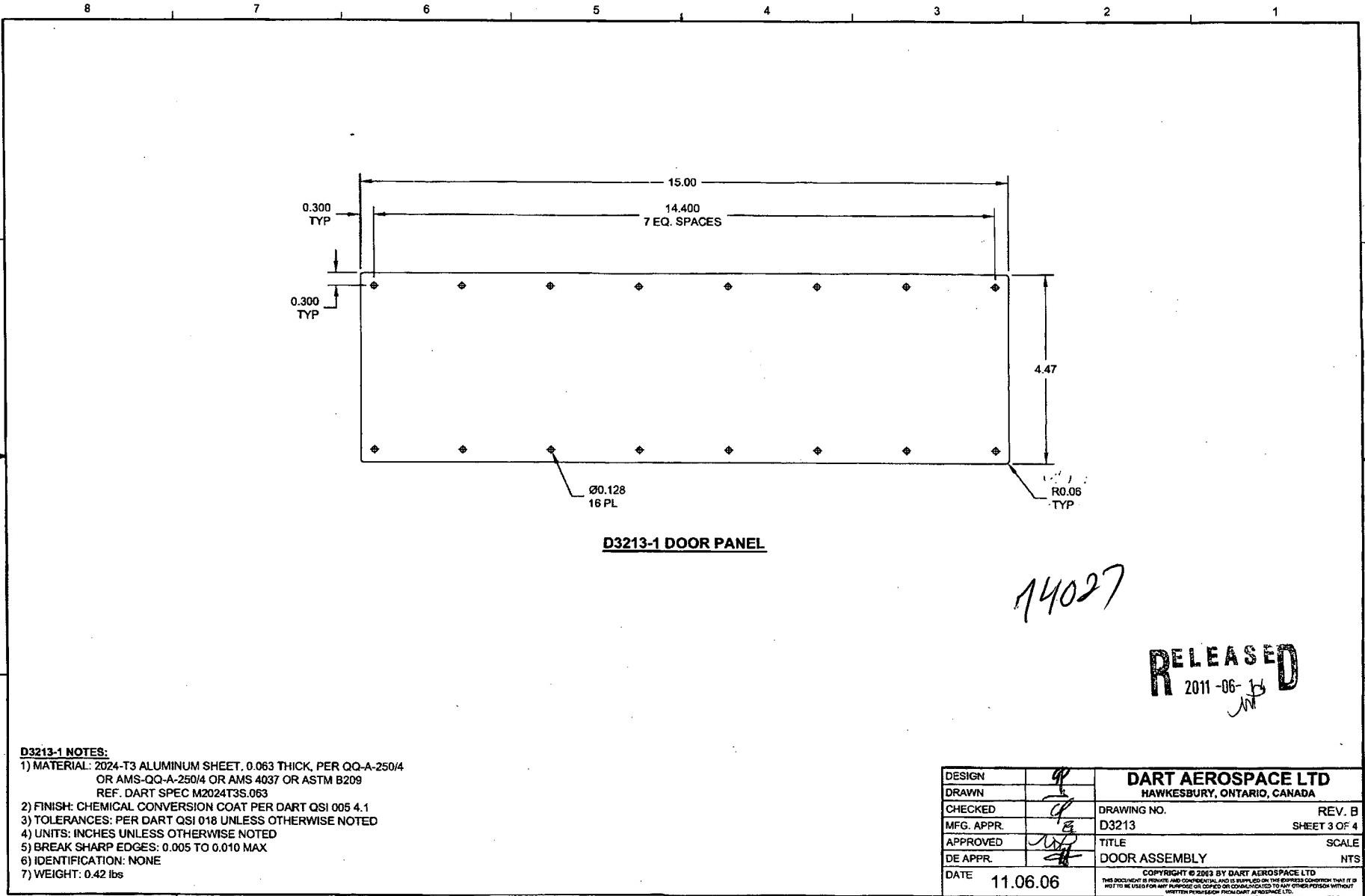
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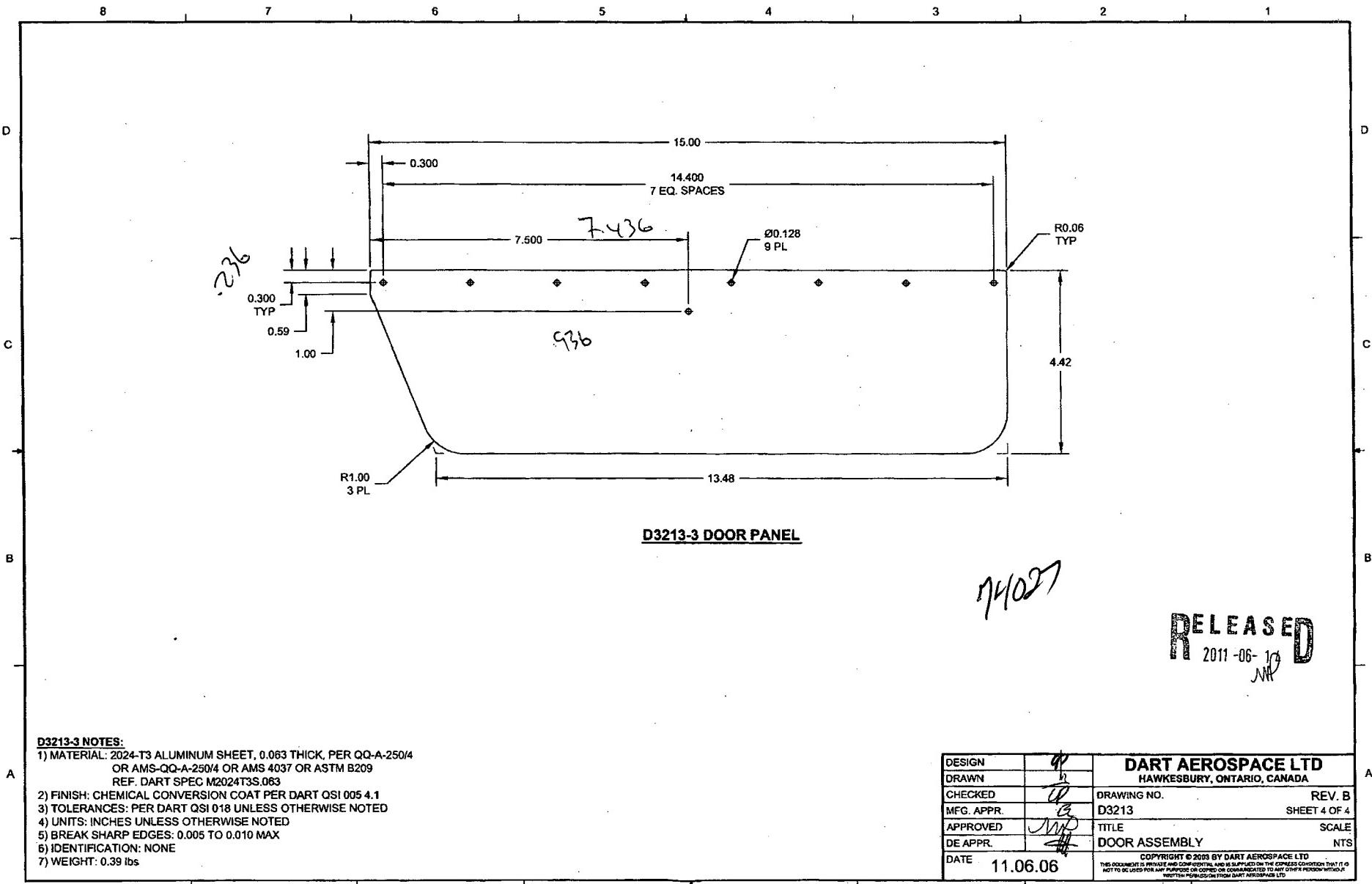
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Dart Aerospace Ltd

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